



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A95-0520-01-1
Job Sheet 173936



Part No: RBE703A95-0520-01-1

Job Qty: 6 ea

Part Name: Quill



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0520-01-1 REV:4 IPP REV:A 18.01.17 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/28/18	0.00	0.00	Start Up Machining-4		
140	CNC Lathe	6 pcs		4/28/18	0.00	1.00	MORI SL-154		
150	QC	6 pcs		4/28/18	0.25	0.50	QC2 Machining-5		
160	QC	6 pcs		4/28/18	0.00	0.00	QC8 Machining-5		
190	Outsource	6 pcs		4/28/18			ATC001-VE ALTECH 10		
200	Packaging	6 pcs		4/28/18	0.00	0.00	Packaging2		
210	QC	6 pcs		4/28/18	0.00	0.00	QC6		
220	Packaging	6 pcs		4/28/18	0.00	0.00	Packaging3-2		
230	QC21-SA	6 Ea		4/28/18	0.00	0.00	QC21		

Part Op 140 - 1-1-Machine as per folio FB790 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.
190 - Issue P/O to ATC: PO 40147 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required
200 - Receive
220 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.000	Round Bar 1.00"	1.3140 ft (.219 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.000	13	64	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S078125



Part: RBE703A95-0520-01-1

Job No: 173936

Serial No/Batch: S078125

Revision: 4

Inspector:

Exp Date: 06/05/2018

Instructions:

Plex 3/8/18 8:14 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

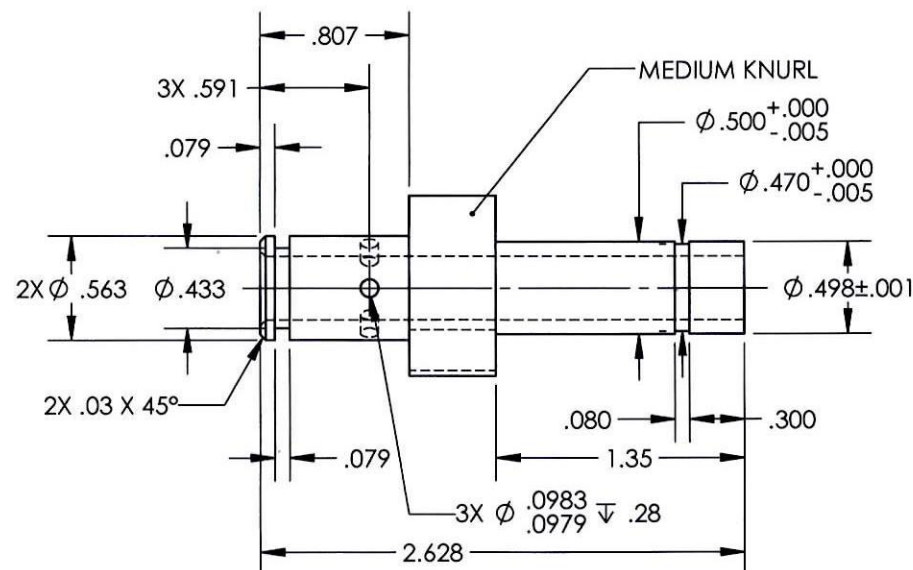
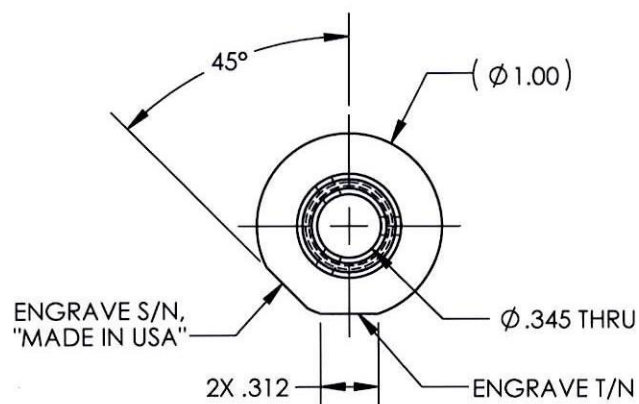
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SECOND FLAT TO ENGRAVE S/N & "MADE IN USA", ADDED NOTE TO DETAIL	5/22/2009	RJC	
2		CH'D P/N -1 MATERIAL FROM STRESS PROOF & FINISH SPEC TO RED ANODIZE PER WP & DW , ADDED MIL SPEC PER WP.	10/29/2009	RJC	RW
3		MODIFIED -1 TO WORK WITH COUPLING	7/31/2012	JAG	
4	14-0209	-1 REMOVED .059 LIP FROM INPUT SIDE OF QUILL. CH'D DIM WAS Ø1.00 IS (Ø1.00). DELETED DIM 3X .591. ADDED DIM 3X .216.	11/5/2014	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 143936
20180501

(-1)

QUILL

DART AEROSPACE	
TITLE ENGINE & HYDRAULIC DRAIN TUBE	
DWG NO. RBE703A95-0520-01-1	REV 4
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	RED ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	EUROCOPTER AS350A
SCALE 1:1	DATE 11/10/2008
	SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040147**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040147
PO Date: 6/8/18
Due Date: 6/13/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173895	RBE350A93-3307-00-05	Hex Head Cap Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	6/13/18	6 pcs	0 pcs	6 pcs	\$18.57142860/pcs	\$111.43
2	173935	RBE703A95-0508-00-1	Quill -Issue P/O to GROUPE ALTECH: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C	Firmed	6/13/18	12 pcs ✓ 12x	0 pcs	12 pcs	\$3.52941176/pcs At 18/06/15	\$42.35
3	173880	RBE350A94-5201-20	Cartridge, Dummy, Fuel -Issue P/O to Groupe Altech: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	6/13/18	10 pcs ✓ 10x	0 pcs	10 pcs	\$3.52941176/pcs At 18/06/15	\$35.29

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	176995	RB877406-5-1	Shaft -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	6/13/18	8 pcs	0 pcs	8 pcs	\$8.57142857/pcs	\$68.57
5	173936	RBE703A95-0520-01-1	Quill -Issue P/O to Groupe Altech : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	6/13/18	12 pcs ✓ 12 x	0 pcs	12 pcs	\$3.52941176/pcs At 18/06/15	\$42.35
Grand Total:										\$300.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 6/11/18 12:45 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(010169-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010169 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Jun-2018		Aman		40147				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBE703A95-0508-00-1 Rev.	RBE703A95-0508-00-1 01-ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12	0	0	0
3	RBE350A94-5201-20 Rev.	RBE350A94-5201-20 01-ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
5	RBE703A95-0520-01-1 Rev.	RBE703A95-0520-01-1 01-ANO-RED [ANODIZE RED] ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12	0	0	0

DAS
38
9-89

Notes Additionnelles / Additional Notes

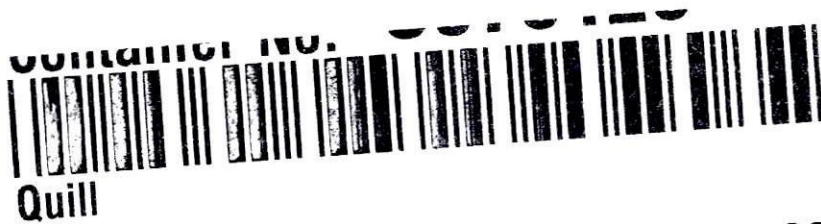
Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



PART NO: RBE703A95-0520-01-1
Serial No/Batch: S078125
Revision:
Operation: Packaging
Change No:

Mfg Date: 06/05/18
Job No: 173936